

Ship Oct 7

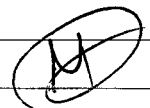
Work Order ID 137440

137440

Page 1

Wednesday, September 30, 2015 4:19:22 PM

Item ID: 41228-202-136-001 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Mounting Bkt./Thermistor Lead Assy
 Start Date: 9/30/15 Start Qty: 1.00 ** Cust Item ID:
 Required Date: 10/07/15 Req'd Qty: 1.00 ** Customer:
 Reference:

Approvals: Process Plan:  Date: 10.9.30 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
41228-202-136	A1

110		0.00							
110									
Small Fab	Memo	0.00							
Small Fab	MANUFACTURE AS PER DWG'S								

120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									

130	Identify as per dwg & Stock Location: _____	0.00							
130									
Packaging	Memo	0.00							
Packaging									

OCT 05 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
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LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Work Order ID 137440

Wednesday, September 30, 2015 4:19:22 PM

137440

Page 2

Item ID: 41228-202-136-001

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Mounting Bkt./Thermistor Lead Assy

Start Date: 9/30/15 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 10/07/15 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MC5 OCT 05 2015*mf*
15-10-05

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Root Cause			FAULT CATEGORY			
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Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____				
Misidentified ☐	Past Due ☐					

Picklist Print

Wednesday, September 30, 2015 4:19:27 PM

Page 1

Work Order ID: 137440

137440

Parent Item: 41228-202-136-001

41228-202-136-001

Parent Item Name: Mounting Bkt./Thermistor Lead Assy

Start Date: 9/30/15

Required Date: 10/07/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 14.07.31 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

NAS1149DN432J

Purchased

No

Each

199.0000

NAS1149DN432J

WASHER

**

2

15-10-01

Location

Loc Qty

Loc Code

CA

199

m129682

199

MS21042L04

Purchased

No

Each

179.0000

MS21042L04

NUT

**

2

15-10-01

Location

Loc Qty

Loc Code

CA

54

M129682

54

ST305

125

125653

117

M130388

8

MS35206-216

Purchased

No

Each

89.0000

MS35206-216

SCREW

**

1

15-10-01

Location

Loc Qty

Loc Code

CA

89

M129682

89

41228-202-090-001

Manufactured

No

Each

9.0000

41228-202-090-001

412 Mounting Bracket

**

1

15-10-01

Location

Loc Qty

Loc Code

CA

9

135705

1

m129682

8

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Picklist Print

Wednesday, September 30, 2015 4:19:27 PM

Page 2

Work Order ID: 137440

137440

Parent Item: 41228-202-136-001

41228-202-136-001

Parent Item Name: Mounting Bkt./Thermistor Lead Assy

Start Date: 9/30/15

Required Date: 10/07/15

Start Qty: 1.00

Required Qty: 1.00

41228-400-010-001

Manufactured No

Each

10.0000

41228-400-010-001

412 Thermistor Harness Assembly

**

1
MS.10.01

Location

Loc Qty

Loc Code

CA

10

m129682

10

1

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

REVISION							
LETTER	DFTSMAN	DATE	DESCRIPTION			APPROVED	DATE
A	DNN	6/13/05	INCRP. E.O. A-1: CHG. 41228-202-090-003 BRACKET TO 41228-202-090-001 BRACKET ASSY ON L/M. MINOR CHANGE - FAR 21.95				

41228-202-090-001
BRACKET ASSY

41228-400-010-001
THERMISTOR LEAD ASSY

MS35206-216 SCREW (1)
AN960JD4 WASHER (4)
MS21042L04 NUT (1)

UNINCORPORATED ECN(s)

01929

AR	CB-200	ACRYLIC ADHESIVE CARSON CITY, NV.				
1	MS21042L04					
2	AN960JD4					
1	MS35206-216					
2	41228-400-010-001	LEAD ASSY				
1	41228-202-090-001	BRACKET ASSY				
	41228-202-136-001	ASSY				
	-001	PART NO.	NAME	STOCK SIZE	MATERIAL	MATL SPEC. ZONE
NO. REQ'D PER ASSY.		LIST OF MATERIAL				
PROPRIETARY RIGHTS NOTICE THESE DATA ARE PROPRIETARY TO ERA AVIATION, INC. NO DISSEMINATION, REPRODUCTION, OR USE OF THESE DATA FOR ANY PURPOSE IS PERMITTED WITHOUT WRITTEN AUTHORIZATION FROM ERA AVIATION, INC. THE FOREGOING DOES NOT APPLY TO VENDOR PARTS.		UNLESS OTHERWISE SPECIFIED	DFTSMAN	T. HARVILLE	8/25/94	TITLE
		X. ± .1	CHECK			MOUNTING BRACKET & THERMISTOR LEAD ASSY
		XX ± .03	STRESS			
		XXX ± .01	PROL	ENGR		
		ANGLES ± .5	HEAT TREAT			
2	41228-202-133	FINISH				
DASH NO. REQ'D PER ASSY		NEXT ASSEMBLY		Era Helicopters LLC		
				DWG. NO.	41228-202-136	REV. A

△ ATTACH LEAD ASSY TO BRACKET IN POSITION AS SHOWN USING CLICK BOND ADHESIVE & HARDWARE LISTED.

NOTE: